

Date: Friday, 7/4/2008 8:47:03 AM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services			Drawing Name	: DOUBLER		
Job Number	: 40254			Part Number	: D32011		
Estimate Number	: 12105			Drawing Number	: D3201 REV B		
P.O. Number	:			Project Number	: N/A		
This Issue	7/4/2008	S.O. No.	:	Drawing Revision	: B		
Prsh Rev.	: NC			Material	:		
First Issue	: / /			Due Date	: 7/20/2008		
Previous Run	: 36755			Qty:	20	Um:	Each
Written By	:			<u>10 08 07 04</u>			
Checked & Approved By	:						
Comment	: Est Rev:A Removed from 9 Digit 06-01-25 JLM						
	: Est Rev:B Now on Waterjet 06-08-14 JLM						

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description:	
1.0	M2024T3S040	2024-T3 .040 sheet	
Comment: Qty.: 0.2898 sf(s)/Unit Total : 5.7960 sf(s) Material: 2024-T3 (QQ-A-250/4) 0.040" thick (M2024T3S.040) Identify for D3201-1 Batch: <u>107572</u> <u>08 07 08</u> <u>(20)</u>			
2.0	WATER JET	FLOW WATER JET	
Comment: FLOW WATER JET 1-Cut as per Dwg D3201 Dwg Rev: <u>B</u> <u>08 07 08</u> <u>(20)</u>			
2-Deburr if necessary <u>ss 08/07/08</u> <u>20</u>			
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
Comment: INSPECT PARTS AS THEY COME OFF MACHINE <u>ml 08 07 08</u> <u>(20)</u>			
4.0	QC8	SECOND CHECK	
Comment: SECOND CHECK <u>S 08/07/08</u> <u>(20)</u>			
5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1	
Comment: SMALL & MEDIUM FAB RESOURCE 1 <u>Deburr Stack</u> <u>u/a</u> <u>Done at step # 22</u>			

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

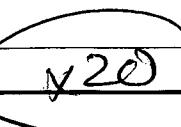
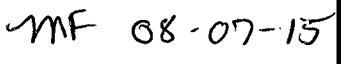
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Job Number: 40254		Part Number: D32011
Job Number: 		
Seq. #:	Machine Or Operation:	Description :
6.0	HAND FINISHING1 	HAND FINISHING RESOURCE #1  <i>MF 08/07/15</i> 
Comment: HAND FINISHING RESOURCE #1 Chemical Conversion Coat as per QSI 005-1		
7.0	QC3 	INSPECT POWDER COAT/CHEMICAL CONVERSION  <i>08-07-15</i> 
Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION		
8.0	PACKAGING 1 	PACKAGING RESOURCE #1  <i>x20</i> 
Comment: PACKAGING RESOURCE #1 Identify and Stock Location: <i>1b</i> <i>8/7/15</i> <i>50</i>		
9.0	QC21 	FINAL INSPECTION/W/O RELEASE  <i>08/07/16</i> 
Comment: FINAL INSPECTION/W/O RELEASE		
Job Completion 		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	40254
Description: Doubler	Part Number:	D3201-1
Inspection Dwg: D3201 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

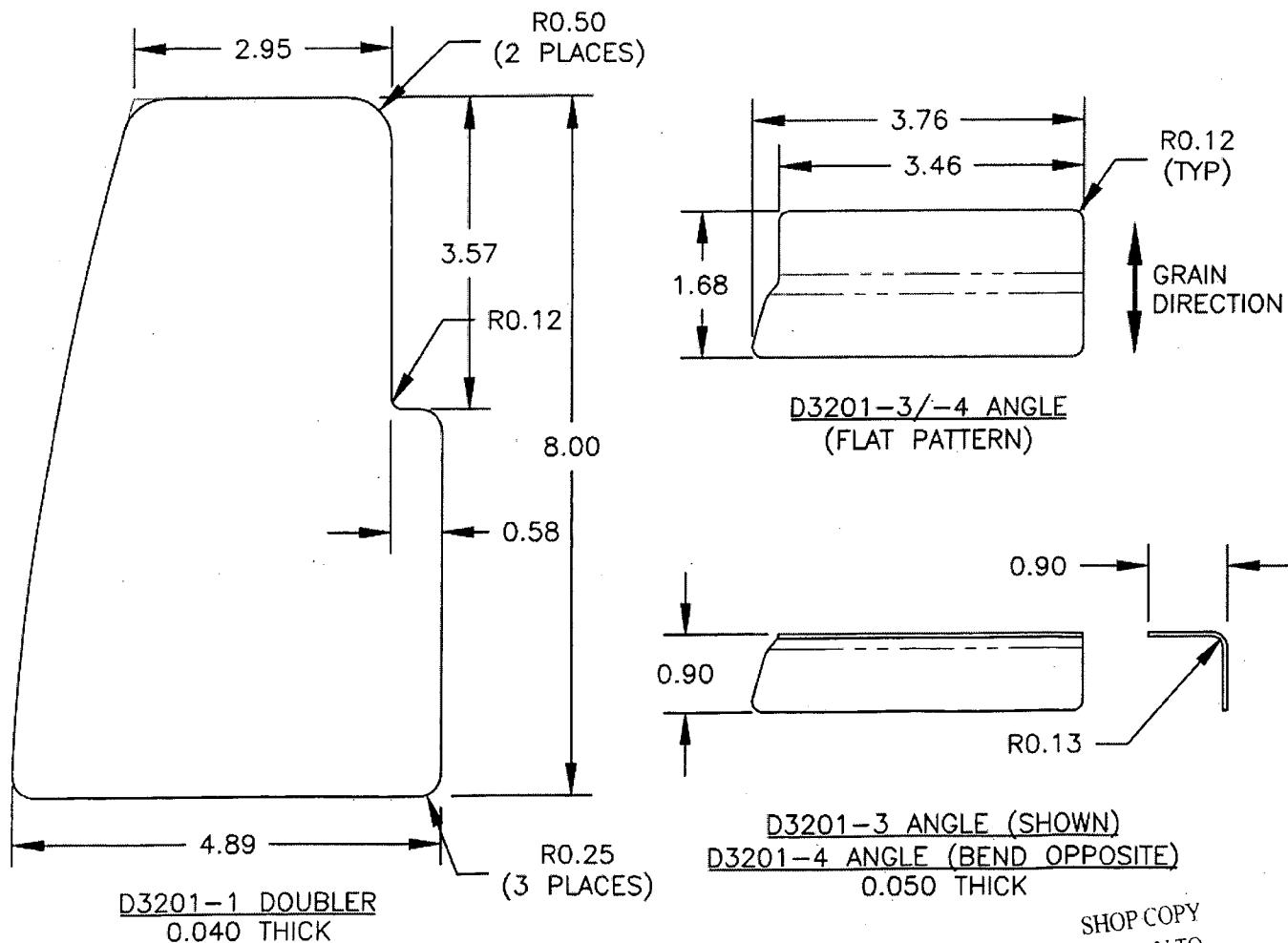
X First Article Prototype

Measured by: <u>M. M</u>	Audited by: <u>S</u>	Prototype Approval: N/A
Date: 08/07/08	Date: 08/07/14	Date: N/A

Rev	Date	Change	Revised by	Approved
A	03.11.28	New Issue	P/O D412-698-015	KJ/RF <i>[Signature]</i> <i>[Signature]</i>

DARTCOPY IS
OUT

DESIGN	DRAWN BY	DART AEROSPACE LTD	
CHECKED	APPROVED	DRAWING NO.	REV. B
		D3201	SHEET 1 OF 1
DATE		TITLE	SCALE
03.11.03		DOUBLER	1:2
A	03.08.07	NEW ISSUE	
B	03.11.03	MODIFY D3201-1, ADD D3201-3/-4	

RELEASED
03.11.14D3201-1/-3/-4 DOUBLER

- 1) MACHINE PARTS PER DWG FILE "D3201-B1.DWG"
- 2) MATERIAL: 2024-T3 ALUMINUM SHEET (QQ-A-250/4)
(REF. DART SPEC M2024T3S)
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 5) ALL DIMENSIONS ARE IN INCHES

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 40254